






shop 27/04




SPLIT.




Work Order ID 57994 - 2

April 21, 2010 11:50:11 AM



Item ID: D3400-1 Accept  Setup Start 
Revision ID:
Item Name: Main Body 9.0 Stop 
Start Date: 4/21/10 Start Qty: 10.00  Cust Item ID:
Required Date: 4/26/10 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3400	Rev A								
105		0.00							
									
Packaging	Memo	0.00							
Packaging	PULL FROM STOCK: 10 X D3400-1 B22561								
110		0.00							
									
HAAS 1	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS CNC vertical machine #1	Memo	0.00							
	RE-MACHINE PER DRWG D3400 REV.A DOWEL PIN HOLES MISSING								
120		0.00							
									
QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00							

W 10/04/21 10






SA 10/05/05 9 10



SA 10/05/05 9 10




Work Order ID 57994

April 21, 2010 11:50:11 AM

Page 2

Item ID:	D3400-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Main Body					
Start Date:	4/21/10	Start Qty: 10.00		Cust Item ID:		
Required Date:	4/26/10	Req'd Qty: 10.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo SAND LIGHTLY (-Touch up Alodine)	0.00 0.00				9	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo SAND LIGHTLY (-Touch up Alodine)	0.00 0.00				X9	0		
150  Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 Memo RE-POWDER COAT RED PER QSI005 Mask all holes <input type="checkbox"/> START TIME: 11:30 AM <input type="checkbox"/> OVEN TEMPERATURE 12:00 PM <input type="checkbox"/> FINISH TIME: 3:20 PM	0.00 0.00				X9	0		

Work Order ID 57994

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Item ID: D3400-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Main Body

Start Date: 4/21/10

Start Qty: 10.00



Cust Item ID:

Required Date: 4/26/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

9 BR 10-5-12

170



Packaging

Packaging

Identify as per dwg & Stock Location: 487

0.00

Memo

0.00

RE-IDENTIFY USING NEW B/N

10-5-12 90 SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/17

PS 10-5-13
(9)

Picklist Print

April 21, 2010 11:50:10 AM

Page 1

Work Order ID: 57994



Parent Item: D3400-1

Parent Item Name: Main Body


Start Date: 4/21/10

Required Date: 4/26/10

Comments: IPP A 05.02.24 New issue KJ/JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3400-1  Main Body		Manufactured	No				Each	10.0000	10.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST487	10	
22561	10	

10 5/11/10 10:05/10

List Lots

April 21, 2010 11:47:36 AM

Page 1 of 1

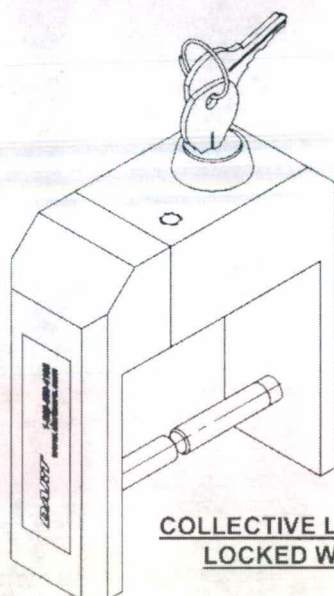
Criteria : Item ID: D3400-1 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D3400-1 Main Body	Main Warehouse ST487	22561	3/12/10	10.0000		QC21		
Total:				10.0000				

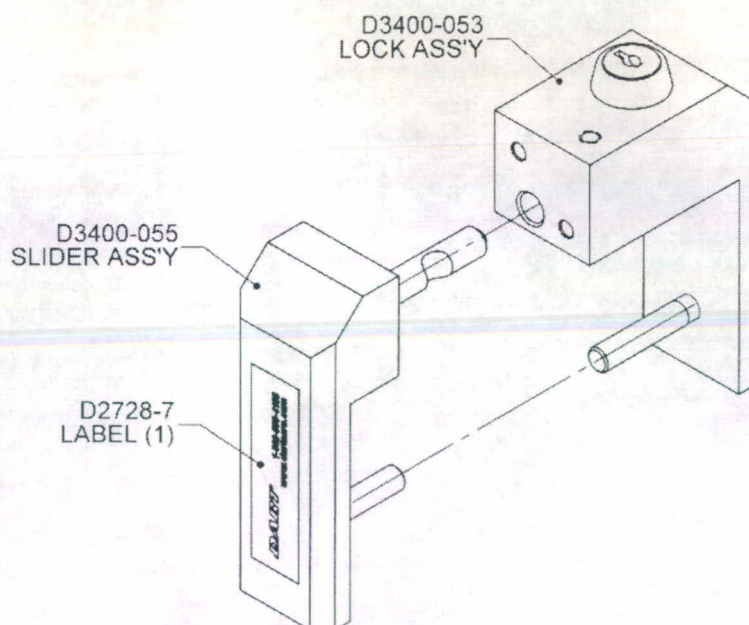
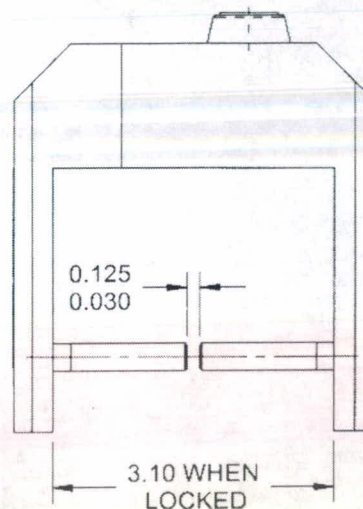
REFERENCE ONLY



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 1 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.02.23	NEW ISSUE	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



D3400-051 AS355 COLLECTIVE LOCK ASS'Y

NOTES:

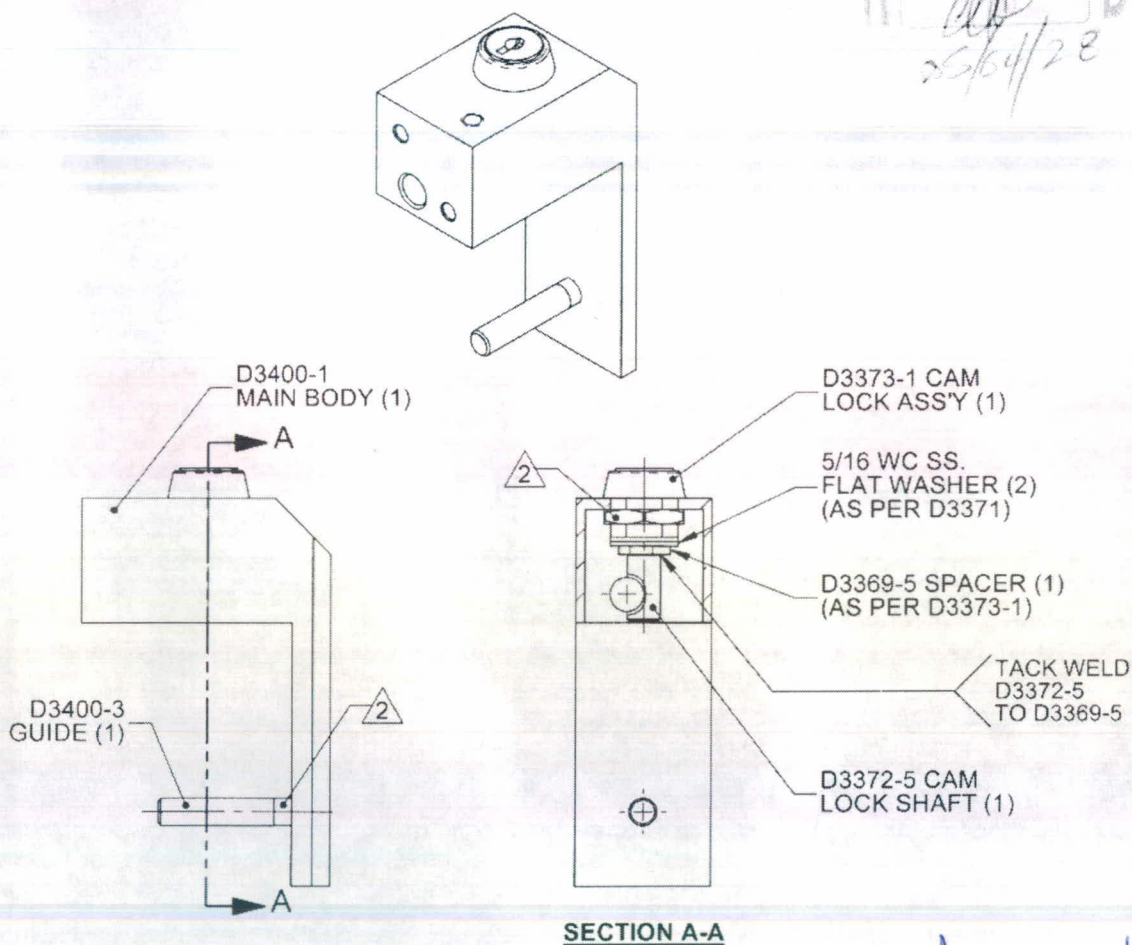
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



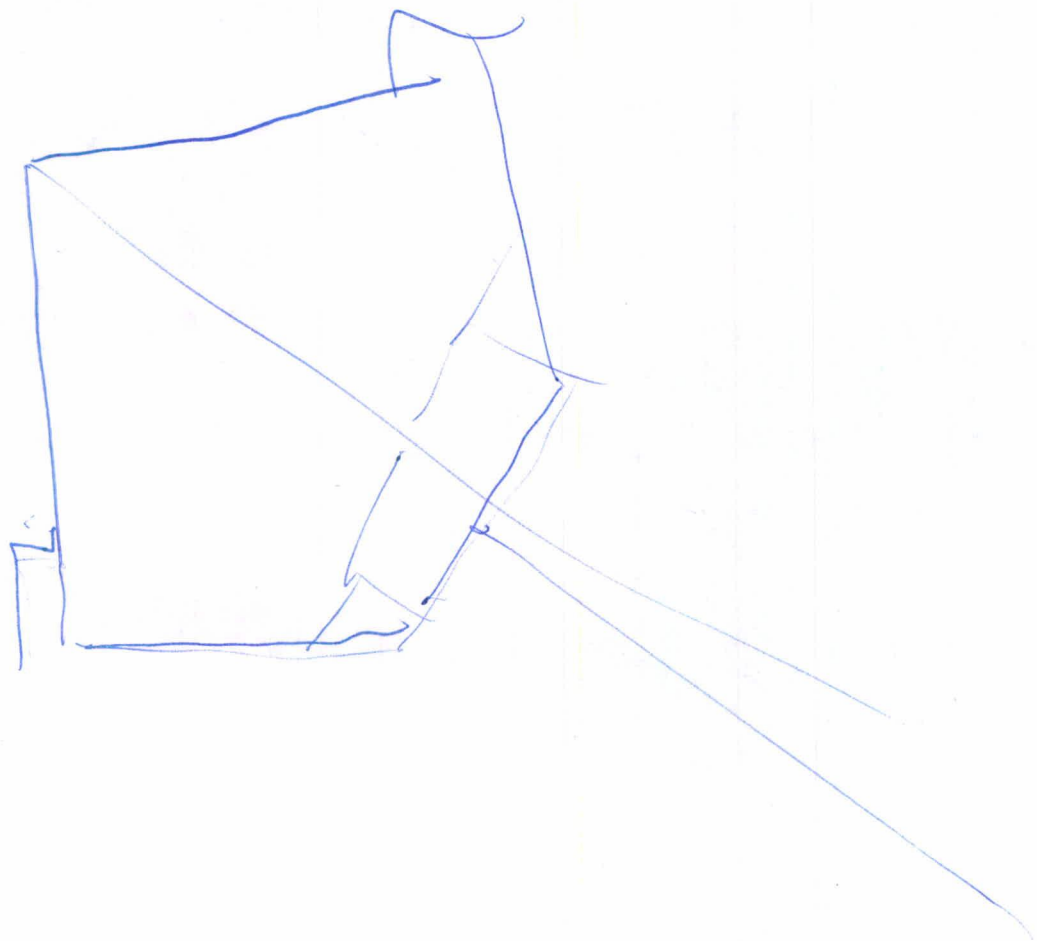
D3400-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

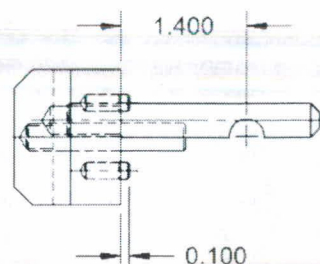
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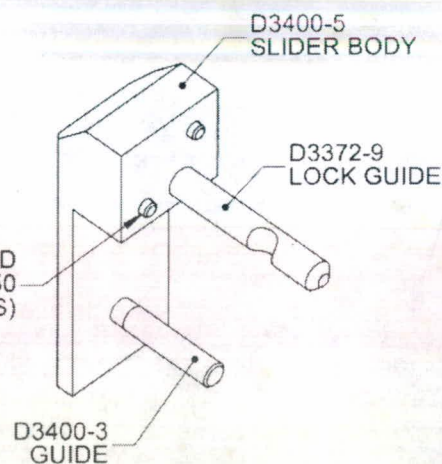
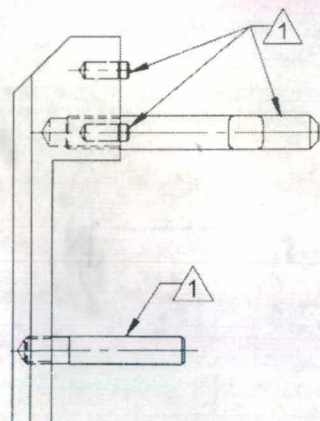




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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



STD. GROUND
DOWEL PIN $\varnothing 3/16 \times 0.50$
(2 PLACES)



D3400-055 SLIDER ASS'Y

NOTES:

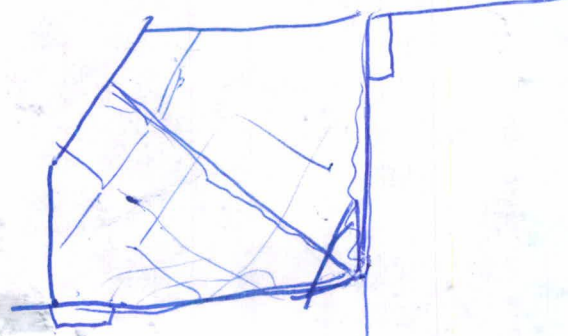
- 1) COVER DOWEL PIN (2 PLACES), D3400-3 AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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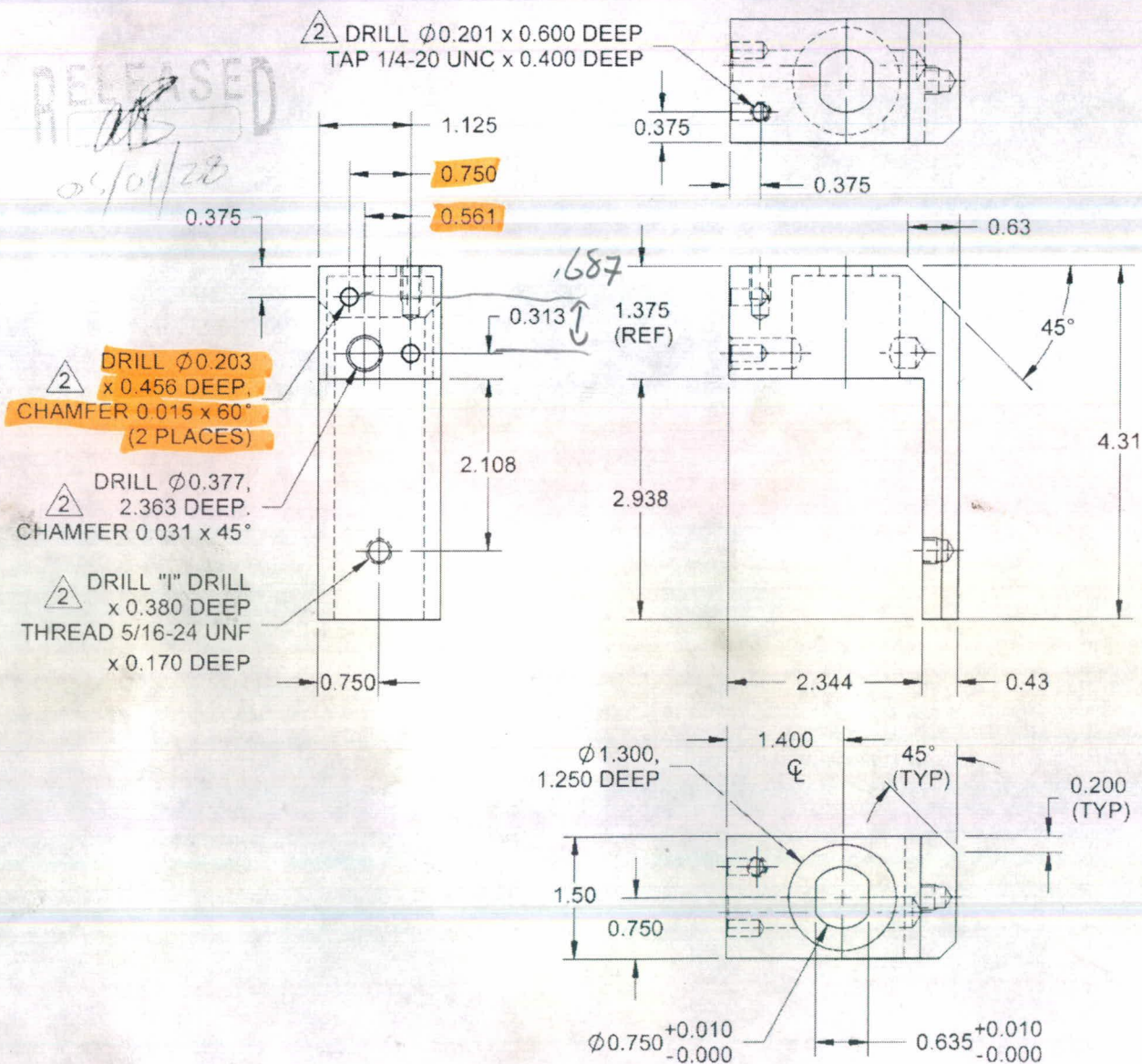
403-250-7370

Tom Payne





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CHECKED	APPROVED	DRAWING NO. D3400	REV. A SHEET 4 OF 6
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2



D3400-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

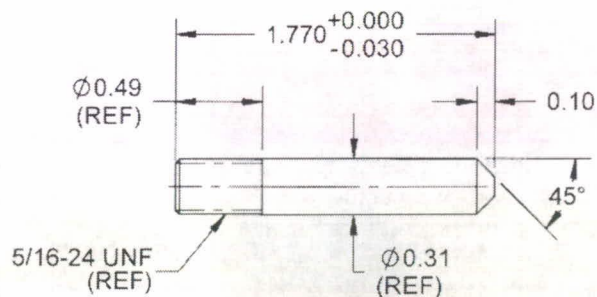
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING



D3400-3 GUIDE

clb
57994

NOTES:

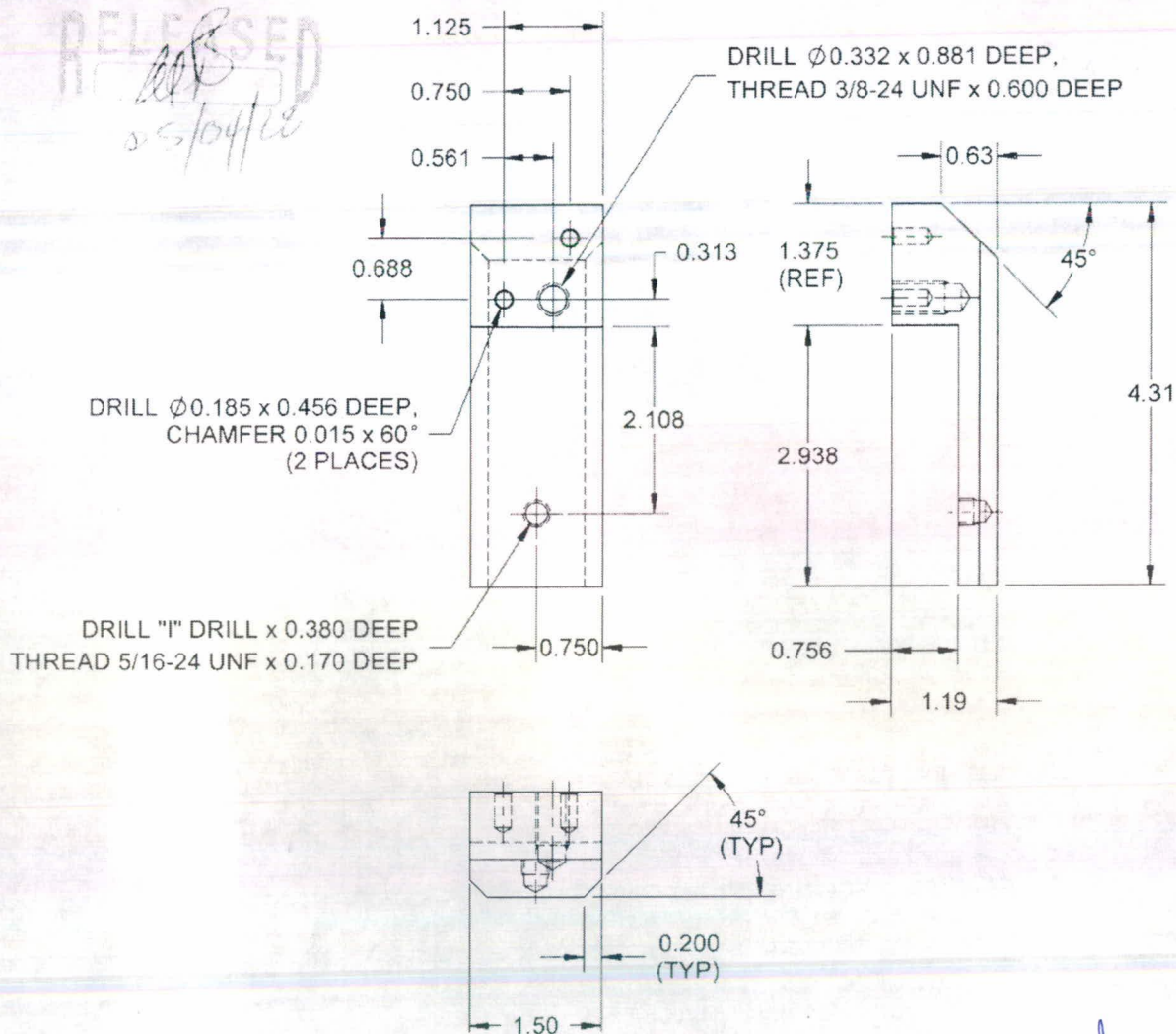
- 1) MATERIAL: AN5-17A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.02.23		TITLE COLLECTIVE LOCK	SHEET 6 OF 6 SCALE 1:2



D3400-5 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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